



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SOLD April 1

D3571-3
Job Sheet 175065



Part No: D3571-3

Job Qty: 10 ea

Part Name: Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/27/18

Job Tracking No:

Due Date: 4/11/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-02-01 JLM IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	4/10/18	4/10/18	0.00	0.00	Start Up Machining-2		DAS 18/04/24
100	Bandsaw	10 pcs	4/10/18	4/10/18	0.00	1.20	Bandsaw1		52 18/04/24
110	CNC Vertical Machining	10 pcs	4/10/18	4/10/18	0.47	6.21	HAAS1-4		9-89 18/04/24
120	QC	10 pcs	4/10/18	4/10/18	0.00	0.00	QC2 Machining-2		18/04/24
130	QC	10 pcs	4/10/18	4/10/18	0.00	0.00	QC8 Machining-2		18/04/24
140	HandFinish	10 pcs	4/10/18	4/10/18	0.00	0.43	HandFinish1		SA 18-04-24
150	Powdercoat	10 pcs	4/11/18	4/11/18	0.00	0.31	Powdercoat3		BRDAS -4-24
160	QC	10 pcs	4/11/18	4/11/18	0.00	0.00	QC3		11 APR 25 2018
170	Packaging	10 pcs	4/11/18	4/11/18	0.00	0.00	Packaging3-1		9-APR 25 2018
180	QC21-SA	10 Ea	4/11/18	4/11/18	0.00	0.00	QC21		9-APR 25 2018

Part Op 100 - Cut blank 2.90 " long

Descriptions: 110 - 1- Mill as per Folio FA681 Rev: & Dwg D3571 Rev: 2-Deburr per dwg D3571

150 - START TIME: 3:25 OVEN TEMPERATURE: 300° FINISH TIME: 3:55

M136370

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	2.4100 ft (.241 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X01.500	2	44	0

Part Specifications

Specifications could not be found.

Plex 3/27/18 10:50 AM Dart.Gagnon.Michelle

*FM137980 2.41 ft.
5064434*

P.T.O.



Container No: S064435



Part: D3571-3

Job No: 175065

Serial No/Batch: S064435

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/24/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

 QA Closed: **DAS 53** 9-89 Date: **JUL 25 2018**

 Work Order update only ☐

Work Order: <u>175065</u> Part No. <u>D3571-3</u> NCR No. <u>18-6916</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☒	Machining	☒	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date: <u>18/04/24</u>	Step #: <u>OP #3</u>	QTY Effective: <u>1</u>	MRB (QS1042) Approval <u>PD</u> 18-04-24
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Description Work Order Deviation	Disposition	Completed By <u>S.C.</u> <u>18/04/24</u>
<u>chamfer too deep</u> <u>(counter sink)</u>	<u>Scrap & Destroy part</u>	Lead hand / Supervisor Approval Verification <u>g</u> 18-04-24
		QC / QA Coordinator Approval <u>PD</u> 18-04-24

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☒	Operator	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☒	Offset/Setup	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☒	Supplier	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	Crushing	☒	Countersink	☒	Off-set	☒	Drawing	☐
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process								
Misidentified	☐	Past Due	OTHER :							